

Work Order ID 69389

Tuesday, May 10, 2011 2:27:25 PM



Page 1

Item ID: D4078-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp Half

Start Date: 5/10/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 5/12/2011 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

RL

Date: *11-05-10*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4078	B								

100

0.00



Bandsaw

Memo

0.00

NO 11/06/08

20

Jeaspa Bandsaw

Cut blank 2.700" long

110

0.00



HAAS I

Pierch

HAAS CNC vertical machine #1

Memo

0.00

Mill as per Dwg and Folio FA929

Folio rev:

Dwg Rev:

issue P/O: 14260

CL 11/06/09 20

Deburr

*Dan's Precision machine as per
dwg D4078 REV.B*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4078-1 PAR #: A/P Fault Category: Supplier NCR: Yes No See next DQA: 11 Date: 11.07.06
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 11 Date: 11/07/06

NCR: <u>369389</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/6/06</u>	<u>#110</u>	<u>Qty +1 Part Scraped by outside Supplier during machining</u>	<u>[Signature]</u> <u>11.07.06</u> <u>OS/092</u>	<u>Adjust Qty to 19 po. Read Attached Email regarding Scrap Part.</u>	<u>Scrapped by Supplier 11/9/06</u>	<u>8</u> <u>11/6/05</u>	<u>[Signature]</u> <u>11.07.06</u> <u>OS/092</u>	<u>[Signature]</u> <u>11/6/06</u>

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120 rec'd

QC
Quality Control

QC2-Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

rec'd + inspect for transit damage
attached c/c to W/O

Rec'd 5/6/27 (19)

130

QC
Quality Control

QC2-Inspect parts - second check

0.00

Memo

0.00

Sulog/28

(HS)

140

HandFinish
Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

19 Bk 11-6-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Start Date: 5/10/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 5/12/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 <i>M115108</i> Memo	0.00 0.00				<i>19</i>	<i>0</i>	<i>11-6-29</i>	
160 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>19</i>	<i>0</i>	<i>11/06/29</i>	
170 Packaging Packaging	Identify as per dwg & Stock Location: <i>121</i> Memo	0.00 0.00				<i>11/7/29</i>	<i>19</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 5/12/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/4 JG

CL11/07/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 10, 2011 2:27:31 PM

Page 1

Work Order ID: 69389



Parent Item: D4078-1



Parent Item Name: Clamp Half

Start Date: 5/10/2011

Required Date: 5/12/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: Ipp Rev:A New Issue 10-05-07 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25 0		Purchased	No			100	f	1.6800	0.223	4.694737			



6061-T6 Bar 1.25 x 1.25

Location

Loc Qty

Loc Code

MAT003

1.68

116135

1.68

117798

4.8 f 11/06/08

D4078-1 P

11/11/07 (19)

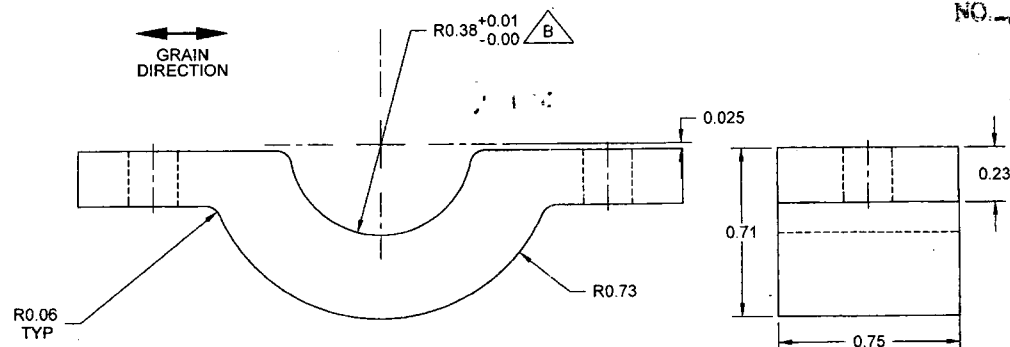
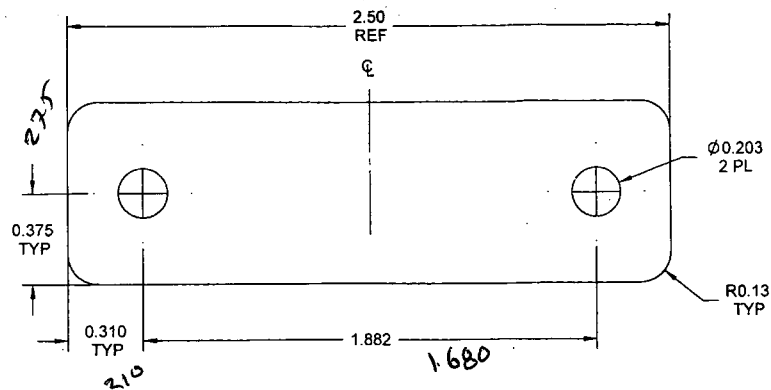
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4078-1 CLAMP HALF

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4078-1" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69389

11-05-10

RELEASED
2010-09-07
WP

B	R0.38 was R0.48.	JB	10.07.30
A	NEW ISSUE	JB	10.02.08
REV.	DESCRIPTION	BY	DATE
DESIGN		JB	
DRAWN		JB	
CHECKED		JB	
MFG. APPR.		JB	
APPROVED		JB	
DE APPR.		JB	
DATE	10.07.30		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4078	REV. B SHEET 1 OF 1
TITLE CLAMP HALF	SCALE NTS
COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DAN'S PRECISION TOOLS INC.

2560 Devine Road, Vars, ON K0A3H0
Tel:(613) 835-3097 Fax:(613) 835-3760
support@dans-precision-tools.com

RE: CERTIFICATE OF COMPLIANCE

To: DART AEROSPACE LTD.
1270 Aberdeen Street
Hawkesbury ON K6A-1K7
Tel: (613) 632-5200
Fax: (613) 632-5246

- We Certify that the part listed below meets the intent of the Purchase Order, and all applicable drawings and specifications.

Date : 27-Jun-11

Purchase Order : PO14260

Packing Slip : 10529

Part Number : D4078-1revB

Quantity : 19

S.1406128

Per: _____

For Dan's Precision Tools Inc.

DAN'S PRECISION TOOLS INC.

Customer: DART AEROSPACE

P.O.: PO14260

W/O: _____

Part #: D4078-1 rev B

Clamp Half _____

Qty: 20 / 9

1 of 1

Chantal Lavoie

From: Linda Lacelle <llacelle@dartaero.com>
Sent: June 28, 2011 7:23 AM
To: 'Khaled - Dan's Precision Tools'; 'JEANLUC MENARD'
Cc: 'Chantal Lavoie'
Subject: RE: PO14260

Hi again Khaled,
I just checked the cost of the blank, it's not worth enough to deduct the cost for the scrap piece, so forget about it...
Thanks for your fast delievry!

Linda

From: Khaled - Dan's Precision Tools [mailto:khaled@dans-precision-tools.com]
Sent: June 27, 2011 3:15 PM
To: Linda Lacelle; JEANLUC MENARD
Cc: 'Chantal Lavoie'
Subject: Re: PO14260

Good afternoon,

Thank you for the updated PO. Everything is correct.

I must admit though that I'm not sure I understand your question. But if it is about subtracting material cost of scrapped piece of D4078-1 from price, you certainly can. If not please advise.

Thank you,
Khaled

----- Original Message -----

From: Linda Lacelle
To: JEANLUC MENARD ; khaled@dans-precision-tools.com
Cc: 'Chantal Lavoie'
Sent: Monday, June 27, 2011 12:53 PM
Subject: RE: PO14260

Hi all,
Line 1,2 & 3 can be short shipped, no problem. Attached is the revised PO, let me know if we got it right. As for the 1 blank scrap, can we remove it from the price of the item?

Thx
Linda Lacelle
Production Manager
Dart Aerospace

From: Jean-Luc Menard [mailto:jmenard@dartaero.com]
Sent: June 27, 2011 12:44 PM
To: L Lacelle
Subject: FW: PO14260

From: Khaled - Dan's Precision Tools [mailto:khaled@dans-precision-tools.com]
Sent: June 27, 2011 12:17 PM
To: DART - Jean-Luc Menard
Subject: PO14260

Bonjour Jean-Luc,

We'll have 14 to 15 lines on this PO delivered this afternoon. Driver will be leaving here around 1:30.

I have, however, a couple of issues I'd like to bring to your attention:

1. D4038-11: One blank was cut short, but we ran 10 pieces accidentally using a D4038-9 blank. Result = we're short 1 piece of D4038-9.
2. D4038-7: Short 1 piece. We ran it as D4038-6.
3. D4078-1: Short 1 piece. We scrapped it during production.
4. You have supplied and we ran 11 pieces of 3573-1 and 3573-8. PO calls for 10 of each. If 11 is what you require please amend PO to match. If not I will send them to you as spares.

Could you please advise as to whether we could ship short for 1,2 and 3 above or if you'd like us to pick up replacement material for more parts?

Give a call when you have a moment. I need to talk to you regarding specs for Rack and Pinion as well

Thank you,
Khaled